Date: Wednesday, 9/12/2007 12:13:24 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: ARM
Job Number	: 34600		
Estimate Number	: 11047		
P.O. Number	:	**Part Number**	: D28441
This Issue	: 9/12/2007 **S.O. No.** :	**Drawing Number**	: D2844 REV A
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : SMALL /MED FAB	**Drawing Revision**	: A
Previous Run	: 34000	**Material**	:
Written By	:	**Due Date**	: 10/10/2007 **Qty:** 30 **Um:** Each
Checked & Approved By	: 07.09.12		
Comment	: Est: B 00.11.01 Removed P/O for Powder Coat - in house processEC		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0500W035	304 RD Tube .500 x .035W

Comment: Qty.: 1.9941 f(s)/Unit Total : ~~19.9406~~ f(s) 59.823
304 RD Tube .500 x .035W
M304TR0500W035
Punch 304/316 Seamless tubing with 2B finish,½" OD x .035 Wall 21.49" long (Hole ctr. to hole ctr.) using 22.314
Jig DT 8012
Batch M105575 SB 07/09/26

2.0	BRAKE NC	NC BRAKE

Comment: BAND SAW SAD 07-09-27 (30)
Form per Dwg D2844 using brake and bending Jig DT 8238-B
Deburr 07/09/26 (30)

3.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP EN 07/09/27 counts (x30)

4.0	POWDER COATING	POWDER COATING

M105068 (30)
Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3 BL 07-09-28

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION EN 07/10/28 counts (x30)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:13:24 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** ARM

Job Number: 34600 **Part Number:** D28441

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC6	DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK
ensure parts are still as per dwg D2844

7.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:_____

8.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

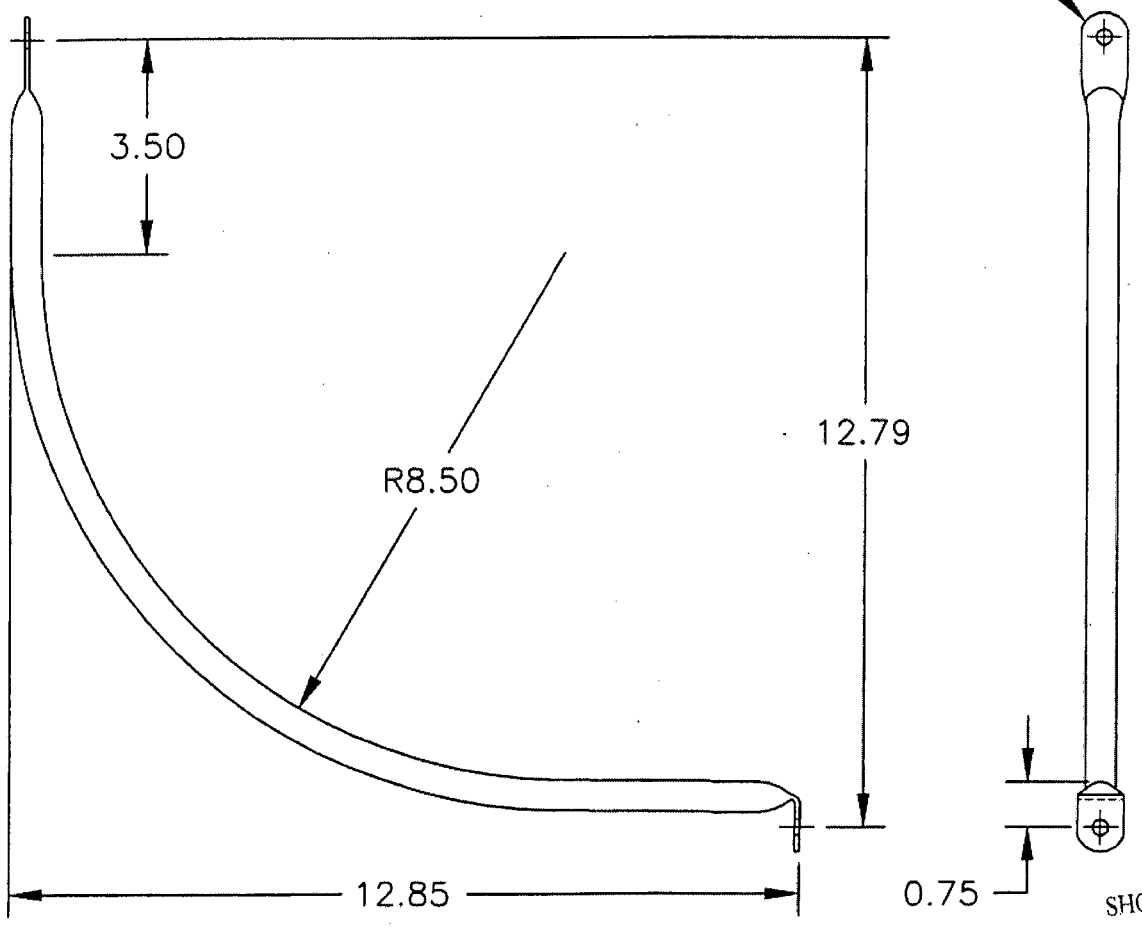
NOTE: Date & initial all entries

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CHECKED PAH	APPROVED	DRAWING NO. D2844	REV. A SHEET 1 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3
A	98.10.14	NEW ISSUE	

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RELEASED 98.10.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-1

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WORK ORDER
NO. 34660

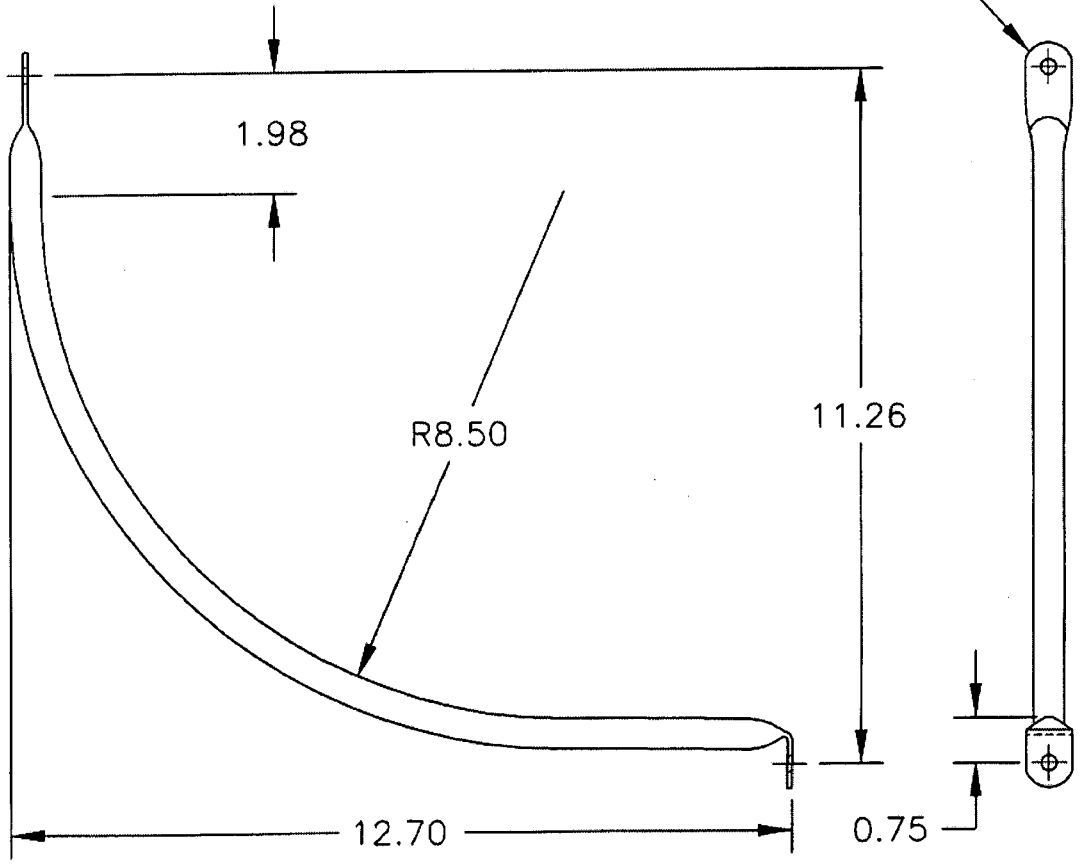
MATERIAL: AISI 304/316 SS TUBE, ø0.50 x 0.035 WALL
ENSURE TUBE IS SEAMLESS
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

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DAH		D2844 SHEET 2 OF 2
DATE		TITLE SCALE
98.10.14		ARM 1:3

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PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-3

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MATERIAL: AISI 304/316 SS TUBE, ø0.50 x 0.035 WALL
ENSURE TUBE IS SEAMLESS
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

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